

Work Order ID 132742

Thursday, May 07, 2015 3:09:47 PM

132742

Page 1

Item ID: D2933-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle LH In, 206
 Start Date: 5/7/2015 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: CG Date: MAR 08 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2933	Rev C

100	HAAS CNC VERTICAL MACHINING #1	0.00				8	Ø		DAS 20 9-89 15-05-31
-----	--------------------------------	------	--	--	--	---	---	--	----------------------------

100
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110	CONVENTIONAL MILLING MACHINE	0.00				8	Ø		DAS 20 9-89 15-05-31
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110
 Mill Conv
 Conventional Milling Machine
 Memo
 Machine Keyway and inspect per attached dimension sheet

120	QC1- Inspection performed by CMM	0.00				8	Ø		DAS 14 9-89 15/06/02
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120
 QC
 Quality Control
 Memo
 0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 2

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Required Date: 5/7/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				8	0		DAS 44 9-89 15/06/03
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				8	0	15-6-8	DAS 34 9-89
140									
HandFinish	Memo	0.02							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				8	0	15-6-8	DAS 34 9-89
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:20 FINISH TIME: 3:50								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 3

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Item ID: D2933-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle LH In, 206

Start Date: 5/7/2015 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				2			DAS 38 9-89
160									JUN 09 2015
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: ST-396	0.00							
170									JUN 09 2015
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									JUN 11 2015
QC	Memo	0.01							
Quality Control									

MLJ JUN 11 2015

DQA: _____ Date: _____



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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Thursday, May 07, 2015 3:09:47 PM

Page 1

Work Order ID: 132742

132742

Parent Item: D2933-1

D2933-1

Parent Item Name: Saddle LH In, 206

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 / *D6101-001* Saddle Billet		Manufactured	No			100	Each	39.0000	1	8			DAS 20 9-89 15-05-30
										**	8		

Location

Loc Qty

Loc Code

MAT042

36

129986

36

MAT045

3

125829

3

5

3

DQA: _____ Date: _____

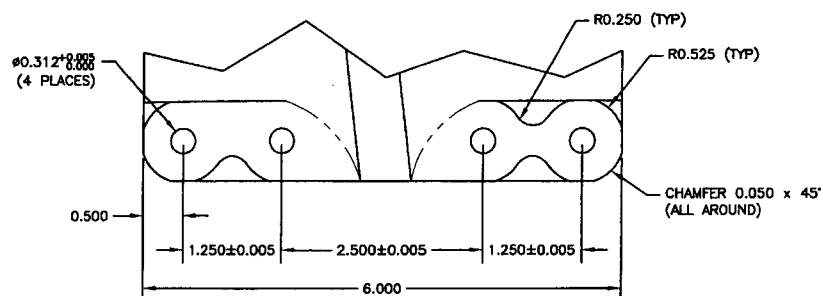


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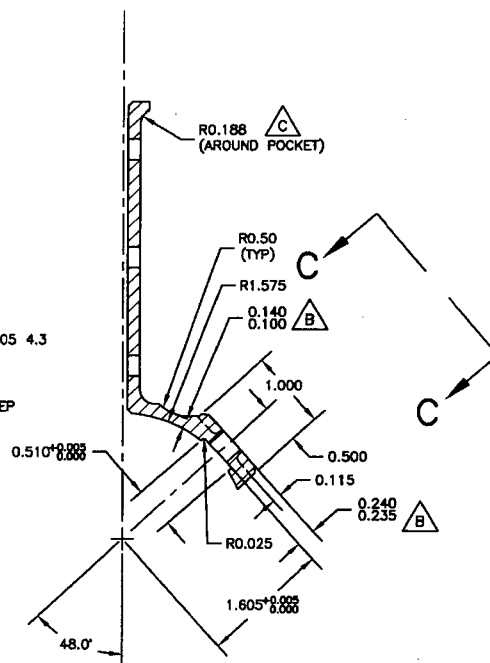
VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

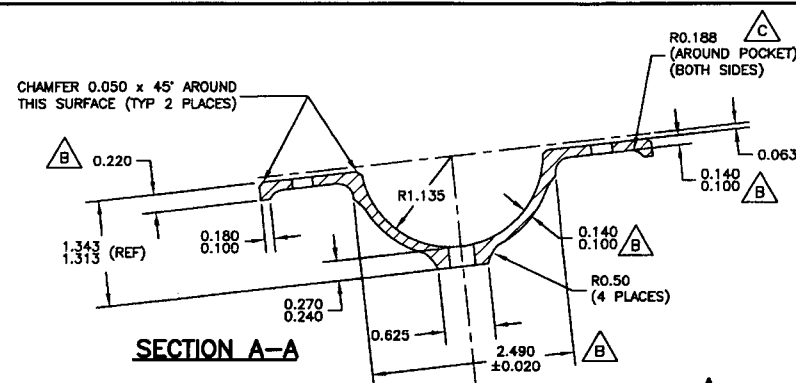
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

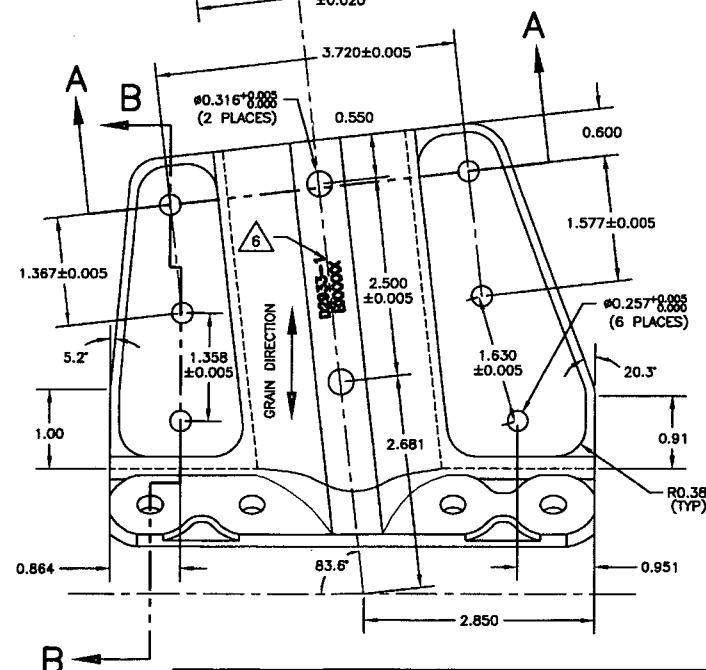
CY MAR 08 2015
W/O: 132742



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		DART AEROSPACE USA, INC. BELLEVUE, WA
		DRAWING NO. D2933
		SHEET 1 OF 1
		SCALE
		SADDLE INSIDE
		2.3

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DART AEROSPACE LTD		Work Order:	132742
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.123	.126	.125	.124	.123
B	0.100	0.140		.125	.126	.126	.127	.124
C	0.100	0.140		.113	.115	.113	.114	.114
D	0.210	0.230		.217	.222	.224	.222	.223
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.237	.237	.236	.235	.236
N	0.100	0.140		.101	.121	.122	.121	.121
O	0.540	0.560		.543	.544	.546	.546	.546
P	0.490	0.510		.497	.496	.495	.499	.497
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.490	2.490	2.490	2.490	2.490
S	0.240	0.270		.245	.250	.248	.249	.248
T	0.100	0.180		.130	.130	.130	.130	.130
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.125	1.145		1.133	1.135	1.137	1.136	1.136
Y	1.565	1.585		1.568	1.572	1.574	1.573	1.5735
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								

DAK
20
9-89

Measured by:	9-89 15-05-30	Date:	
Audited by:	FK	Date:	15/06/03
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DART AEROSPACE LTD		Work Order:	132742
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6 #	7 #	8 #	4	5
A	0.100	0.140		.124	.125	.124		
B	0.100	0.140		.127	.126	.125		
C	0.100	0.140		.113	.113	.113		
D	0.210	0.230		.222	.222	.223		
E	1.245	1.255		1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258		
L	0.312	0.317		.314	.314	.314		
M	0.235	0.240		.237	.237	.236		
N	0.100	0.140		.121	.121	.121		
O	0.540	0.560		.546	.544	.546		
P	0.490	0.510		.497	.495	.498		
Q	3.715	3.725		3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490		
S	0.240	0.270		.249	.249	.244		
T	0.100	0.180		.130	.130	.130		
U	1.625	1.635		1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316		
X	1.125	1.145		1.136	1.1365	1.1356		
Y	1.565	1.585		1.573	1.5728	1.5727		
Z	0.178	0.198		.188	.188	.188		
AA								
AB								
AC								
AD								
AE								

DA: Accept/Reject

Measured by:	20 9-89 15-05-31	Date:	
Audited by:	FK	Date:	15/06/03
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	



Part Number: D2933-1	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 132742

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
A	0.120	+0.020/-0.020	0.124	0.126	0.125	0.124	0.123
B	0.120	+0.020/-0.020	0.127	0.126	0.126	0.127	0.124
C	0.120	+0.020/-0.020	0.113	0.115	0.113	0.114	0.114
D	0.2200	+0.0100/-0.0100	0.2243	0.2233	0.2231	0.2232	0.2230
E	1.2500	+0.0050/-0.0050	1.2501	1.2501	1.2503	1.2505	1.2501
F	1.2500	+0.0050/-0.0050	1.2494	1.2499	1.2509	1.2494	1.2494
G	2.5000	+0.0050/-0.0050	2.4997	2.4999	2.4988	2.4995	2.4999
H	0.510	+0.005/0.000	0.511	0.511	0.511	0.511	0.511
I	1.5770	+0.0050/-0.0050	1.5772	1.5777	1.5780	1.5773	1.5774
J	2.5000	+0.0050/-0.0050	2.4991	2.4996	2.4995	2.4996	2.4999
K	0.2570	+0.0050/-0.0010	0.2577	0.2577	0.2577	0.2575	0.2576
L	0.3120	+0.0050/-0.0010	0.3130	0.3131	0.3129	0.3129	0.3130
M	0.235	+0.005/0.000	0.237	0.237	0.236	0.236	0.236
N	0.1200	+0.0200/-0.0200	0.1232	0.1223	0.1218	0.1220	0.1217
O	0.5500	+0.0100/-0.0100	0.5501	0.5485	0.5495	0.5497	0.5503
P	0.5000	+0.0100/-0.0100	0.4998	0.4995	0.4944	0.4994	0.5029
Q	3.7200	+0.0050/-0.0050	3.7191	3.7182	3.7197	3.7182	3.7184
R	2.4900	+0.0200/-0.0200	2.4954	2.4953	2.4958	2.4954	2.4950
S	0.255	+0.015/-0.015	0.249	0.250	0.248	0.248	0.248
T	0.140	+0.040/-0.040	0.130	0.130	0.130	0.130	0.130
U	1.6300	+0.0050/-0.0050	1.6301	1.6296	1.6294	1.6300	1.6300
V	1.3670	+0.0050/-0.0050	1.3680	1.3674	1.3669	1.3669	1.3677
W	0.3160	+0.0050/-0.0010	0.3153	0.3152	0.3151	0.3150	0.3150
X	1.135	+0.010/-0.010	1.136	1.135	1.137	1.136	1.136
Y	1.575	+0.010/-0.010	1.573	1.572	1.574	1.574	1.574
Z	0.1880	+0.0100/-0.0100	0.1910	0.1908	0.1917	0.1913	0.1915

Measured by:
Mathieu Lamarche

Date:
2015-6-2

Audited by:
DAS
44
9-89

Date:

15/06/03



Part Number: D2933-1	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 132742

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual		
A	0.120	+0.020/-0.020	0.124	0.125	0.124		
B	0.120	+0.020/-0.020	0.127	0.126	0.125		
C	0.120	+0.020/-0.020	0.113	0.113	0.113		
D	0.2200	+0.0100/-0.0100	0.2243	0.2230	0.2177		
E	1.2500	+0.0050/-0.0050	1.2501	1.2499	1.2502		
F	1.2500	+0.0050/-0.0050	1.2494	1.2501	1.2497		
G	2.5000	+0.0050/-0.0050	2.4997	2.4995	2.4998		
H	0.510	+0.005/0.000	0.511	0.511	0.511		
I	1.5770	+0.0050/-0.0050	1.5772	1.5780	1.5768		
J	2.5000	+0.0050/-0.0050	2.4991	2.4997	2.4985		
K	0.2570	+0.0050/-0.0010	0.2577	0.2575	0.2581		
L	0.3120	+0.0050/-0.0010	0.3130	0.3131	0.3126		
M	0.235	+0.005/0.000	0.237	0.237	0.236		
N	0.1200	+0.0200/-0.0200	0.1232	0.1220	0.1017		
O	0.5500	+0.0100/-0.0100	0.5501	0.5488	0.5489		
P	0.5000	+0.0100/-0.0100	0.4998	0.4991	0.4997		
Q	3.7200	+0.0050/-0.0050	3.7191	3.7189	3.7182		
R	2.4900	+0.0200/-0.0200	2.4954	2.4948	2.4951		
S	0.255	+0.015/-0.015	0.249	0.249	0.244		
T	0.140	+0.040/-0.040	0.130	0.130	0.130		
U	1.6300	+0.0050/-0.0050	1.6301	1.6290	1.6300		
V	1.3670	+0.0050/-0.0050	1.3680	1.3674	1.3673		
W	0.3160	+0.0050/-0.0010	0.3153	0.3153	0.3150		
X	1.135	+0.010/-0.010	1.136	1.137	1.136		
Y	1.575	+0.010/-0.010	1.573	1.573	1.573		
Z	0.1880	+0.0100/-0.0100	0.1910	0.1914	0.1908		

Measured by:
Mathieu Lamarche

Date:
2015-6-2

Audited by:

DAS
44
9-89

Date:

15/06/03